: HELI-ACCESS STEP RH (FOLDING)

Date: User: Thursday, 17/07/2008 11:50:32 AM

Julie Lecocq

## **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 40269

**Estimate Number** 

P.O. Number

This Issue

Prsht Rev.

First Issue

**Previous Run** 

: 17/07/2008

: 12568

: NC

: // : 36498

Type

S.O. No. :

: LARGE FAB ASSY

Material

**Drawing Name** 

Part Number

**Drawing Number** 

Project Number

**Drawing Revision** 

**Due Date** 

: 28/07/2008

: D412630034

· IIN D412-630

: N/A

Qty:

4 Um:

Each

Written By Checked & Approved By

Comment

: Est. Rev:A est rev B

New Issue 06-11-08

ecn1019, added D2807-041

EC verified by:DD

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

DOCUMENT CONTROL

1.0

2.0

08,7.30

Photocopy bluefile & create labels per PPP D412-630-034 CHG003

D2012107

Clevis

1.0000 Each(s)/Unit Comment: Qty.:

Comment: DOCUMENT CONTROL

Total:

4.0000 Each(s)

Clevis Pick:

Qty

Part Number 1

D2012-107

Description Clevis

3.0

D2803042

Bracket Assembly

1.0000 Each(s)/Unit Total:

Bracket Assembly RH

4.0000 Each(s)

Comment: Qty.: **Bracket Assembly** 

Pick:

Qty Part Number Description

Batch

D2803-042 1 D2804042

1340/

4.0

Bracket Assembly

Comment: Qty.:

1.0000 Each(s)/Unit Total:

4.0000 Each(s)

**Bracket Assembly** 

Pick:

Qty

Part Number D2804-042

Description

Bracket Assembly RH

5340/S

Dart Ae	rospace L	_td								
W/O:			W	ORK ORDER CH	IANGES					
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cat	enory.	NC	R· Yes	No DO	Δ.	Date:	
			raun oat	gory.					_ Date: _ _ Date: _	
NCR:		:\	VORK OR	DER NON-CONFO	DRMANCE	(NCR	)			
D.4.T.E.		Description of NC	Corrective Action Section B				Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date		ion C	Chief Eng	QC Inspector

Thursday, 17/07/2008 11:50:32 AM Date: ' Julie Lecoca User: **Process Sheet** Drawing Name: HELI-ACCESS STEP RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 40269 Part Number: D412630034 Job Number: Description: Seq. #: Machine Or Operation: Gas Spring Assembly D2807041 5.0 Total: 8.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Support Prop Batch: Washer D2813 6.0 8.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Washer Pick: Description Qty Part Number 34020 Washer 2 D2813 7.0 D3562042 Step Assembly, RH 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Step Weldment LH Pick: Description Qty Part Number Batch 40 289 Step Weldment RH 1 D3562-042 Bushing D33951 8.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) Bushing Pick: 1333578 Description Qtv Part Number Bushing D3395-1 AN3C21A BOLT 9.0 8.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: **BOLT** Pick: Batch Qty Part Number Description M101189 AN3C21A 2 Bolt

Form: rprocess

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### **Dart Aerospace Ltd**

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto		
Part No		PAR #:	Fault Category:	NCF	R: Yes	No DC	QA:	_ Date: _			
					QA: N/	C Clos	ed:	_ Date: _			
NCR:		WO	RK ORDER NON-CON	ORMANCE	(NCR)	)					
		Description of NC	Corrective Action	Section B	*	Vorif	ication	Approval	Approval		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
						<u>.</u>					
		r									

Thursday, 17/07/2008 11:50:32 AM Date: ' Julie Lecocq User: **Process Sheet** Drawing Name: HELI-ACCESS STEP RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630034 Job Number: 40269 Job Number: Description: Seq. #: **Machine Or Operation:** Bolt AN8C16 10.0 Total: 8.0000 Each(s) 2.0000 Each(s)/Unit Comment: Qty.: Bolt Pick: Batch 1106066 Part Number Description Qty 2 **AN8C16** Bolt AN310C8 Nut 11.0 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Comment: Qty.: Nut Pick: M105426 Qty Part Number Description AN310C8 Nut 2 MS24665302 Cotter Pin 12.0 8.0000 Each(s) 2.0000 Each(s)/Unit Total: Comment: Qty.: Cotter Pin Pick: Description Batch Qty Part Number 2 MS24665-302 Cotter Pin (or AN380C3-4) 13.0 NAS1515H3 24.0000 Each(s) Comment: Qtv.: 6.0000 Each(s)/Unit Total: Washer Pick: Qty Part Number Description 4/04/01 6 NAS1515H3 Washer WASHER 14.0 NAS1515H5L Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) WASHER Pick: Batch M106541 8/7/18 Qty Part Number Description Washer NAS1515H5L

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W/O:			٧	VORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	,											
				<del></del>								
Part No	·	PAR #:	Fault Ca	tegory: N	CR: Yes	No <b>DQ</b> A	\:	Date:				
					QA: N	/C Closed	!:	Date:				
NCR:			WORK OR	DER NON-CONFORMANO	CE (NCR	2)						
		Description of NC	Description of NC Corrective Action Section B			Verific	ation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C					Chief Eng	QC Inspector
			·									
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Thursday, 17/07/2008 11:50:32 AM Date: User: Julie Lecoca **Process Sheet** Drawing Name: HELI-ACCESS STEP RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Job Number: 40269 Part Number: D412630034 Job Number: Seq. #: **Machine Or Operation:** Description: NAS1515H8 Washer 15.0 Total: 16.0000 Each(s) Comment: Qty.: 4.0000 Each(s)/Unit Washer Pick: 1. Qty Part Number Description Washer 4 NAS1515H8 MS210433 Nut 16.0 4.0000 Each(s)/Unit Total: 16.0000 Each(s) Comment: Qty.: Nut Pick: Description Batch -Qty Part Number MS21043-3 Nut 4 17.0 MS24693C280 Screw Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Screw Pick: Qty Part Number Description MS24693-C280 Screw (or MS24694-C565) SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 18.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: 104929 COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M 164251

SAD 08/07/30

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



YX

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W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		•									

Part No: D412 - 630-034 PAR #: NA Fault Category: Spolid A(Nin. Meridia NCR: Yes No DQA: Date: 08/07/30

: N/C Closed: Date: <u>08 57/3</u>

NCR:	0269	W	ORK OR	DER NON-CONFORMANCE	(NCR)			
DATE	STEP	Description of NC Section A						
81733	18.0	Durking Assembly it was bund by assembly that ligas spring D2007-041 was not fastic functions corectle	Postur	Remove and Replace Qty @ Game to enq	540 54100/20	osloslas	Nosiwa	Coluntas
		R.C. Supplier/monoCacturing defect.						

Thursday, 17/07/2008 11:50:32 AM Date: User: Julie Lecocq **Process Sheet** Drawing Name: HELI-ACCESS STEP RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630034 Job Number: 40269 Job Number: Seq. #: **Description: Machine Or Operation:** PACKAGING RESOURCE #1 PACKAGING 1 20.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit Bushing 21.0 D28061 8.0000 Each(s) 2.0000 Each(s)/Unit Total: Comment: Qty: Bushing Pick: Packing Kit Qty Part Number Description D2806-1 Bushing 2 Bushing D28063 22.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Bushing Pick: Packing Kit Part Number Description Qty 2 D2806-3 Bushing 23.0 D28105 Strut 4.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Strut Pick: Packing Kit Part Number Description SW 1 D2810-5 Strut D33961 24.0 Spacer Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Spacer Pick: Packing Kit Qty Part Number Description 2 D3396-1 Spacer AN4C6A 25.0 4.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Bolt Pick: Packing Kit Part Number Description Batch

Form: rprocess

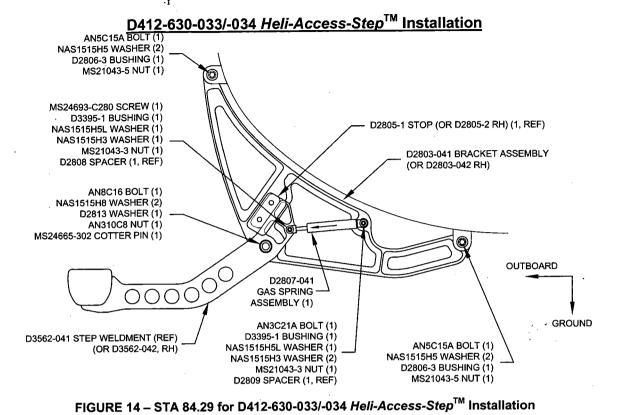
Page 5

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W/O:			W	ORK ORDER CH	ANGES		······································			
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	egory:	NC					
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DATE	OTED	Description of NC		Corrective Action Section			Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	otion 	Sign & Date		ion C	Chief Eng	QC Inspector
	1		1				Ì		1	

Thursday, 17/07/2008 11:50:32 AM Date: User: Julie Lecoca **Process Sheet** Drawing Name: HELI-ACCESS STEP RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630034 Job Number: 40269 Job Number: Description: Seq. #: **Machine Or Operation:** Bolt 1 AN4C6A Bolt AN4C10A 26.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Bolt Pick: Packing Kit Batch Part Number Description <u>s</u>0 M/01/89 Bolt AN4C10A AN4C15A Bolt 27.0 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Comment: Qty.: Bolt Pick: Packing Kit Qty Part Number Description Batch M107087 2 AN4C15A Bolt AN44C7A Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Eyebolt Pick: Packing Kit Qty Part Number Description 1101711 AN44-C7A Eyebolt 1 AN5C15A 29.0 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Comment: Qty: Bolt Pick: Packing Kit Part Number Description Qty M105125 2 AN5C15A Bolt 30.0 NAS1515H4 Washer Comment: Qty.: 28.0000 Each(s) 7.0000 Each(s)/Unit Total: Washer Pick: Packing Kit Batch Qty Part Number Description W/06219 NAS1515H4 Washer

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W/O:			WC	ORK ORDER CHANGE	ES				<del>(1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -</del>
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	nory:	NCR: Yes	No DO	Δ-	Date:	
· urerto	-			<u></u>			Date:		
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	2)			
		Description of NC		Corrective Action Section B			cation	Approvai	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	1	ion C	Chief Eng	QC Inspector
					:				

Thursday, 17/07/2008 11:50:32 AM Date: \* User: Julie Lecocq **Process Sheet** Drawing Name: HELI-ACCESS STEP RH (FOLDING) Customer: CU-DAR001 Dart Helicopters Services Part Number: D412630034 Job Number: 40269 Job Number: Description: Seq. #: **Machine Or Operation:** NAS1515H5 Washer 31.0 Comment: Qty.: 7.0000 Each(s)/Unit Total: 28.0000 Each(s) Washer Pick: Packing Kit Qty Part Number Description NAS1515H5 Washer MS210434 Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) Nut Pick: Packing Kit Qtv Part Number Description MS21043-4 Nut MS210435 3.0000 Each(s)/Unit Total: 12.0000 Each(s) Comment: Qty.: Nut Pick: Packing Kit Part Number Description MS21043-5 Nut QC4 34.0 Comment: INSPECT 100% KITS FOR COMPLETENESS PACKAGING RESOURCE #1 PACKAGING 35.0 Comment: PACKAGING RESOURCE #1 Identify and pack for shipping as per PPP D412-630-034 Location: PPP Rev: FINAL INSPECTION/W/O RELEAS 36.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion



(View rotated 90° CW) AN4C15A BOLT (1) NAS1515H4 WASHER (2) D2806-1 BUSHING (1) 0 MS21043-4 NUT (1) D2805-1 STOP (OR D2805-2 RH) (1, REF) AN3C16A BOLT (2, REF) NAS1515H3 WASHER (4, REF) MS24693-C280 SCREW (1) D3395-1 BUSHING (1) MS21043-3 NUT (2, REF) NAS1515H5L WASHER (1) NAS1515H3 WASHER (1) D2804-041 BRACKET ASSEMBLY (OR D2804-042 RH) MS21043-3 NUT (1) D2808 SPACER (1, REF) D3562-041 STEP WELDMENT (REF) (OR D3562-042, RH) OUTBOARD 0 D2807-041 **GROUND** GAS SPRING ASSEMBLY (1) **SHOP COPY** AN8C16 BOLT (1) AN3C21A BOLT (1) **RETURN TO** NAS1515H8 WASHER (2) D3395-1 BUSHING (1) AN4C15A BOLT (1) D2813 WASHER (1) NAS1515H5L WASHER (1) **ENGINEERING** NAS1515H4 WASHER (2) AN310C8 NUT (1) NAS1515H3 WASHER (2) **UNCONTROLLED COPY** D2806-1 BUSHING (1) MS24665-302 COTTER PIN (1) MS21043-3 NUT (1) MS21043-4 NUT (1) SUBJECT TO AMENDMENT D2809 SPACER (1, REF) WITHOUT NOTICE FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation WORK ORDE

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(View rotated 90° CW)

Revision:

07.09.30 Date:

NO.